Work Order ID 57825



Page 1

April 16, 2010 11:31:14 AM

Required Date: 23/04/2010

Item ID: **Revision ID:** D3493-1

Accept



Setup Start



Item Name: Start Date:

16/04/2010

Washer

Start Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals:

Date: 10-1/1/ Tooling:

Date:

Run

Start

Stop



Req'd Qty: 40.00

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ **Work Center ID**

Operation Description Set Up/ **Run Hours** Draw Number Draw Rev.

Plan Accept Qty Code

Reject **Qty**

Reject Insp. Number Stamp

Draw Nbr D3493

Rev A

Hardinge

Revision Nbr

Hardinge CNC LATHE SMALL

Memo

0.00

0.00

Hardinge CNC Lathe Small

1-Turn as per Folio FA626 & Dwg D3493 □2-Deburr

JL 10/04/18



110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

120

0.00

S& 10/04/13 (27)

Quality Control

Memo

QC8- Inspect parts - second check

0.00

1. 3

Dart A	Aerospace	Ltd
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W/O:			W	ORK ORDER CHANGE	S	·			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	R	esolution:	Dispositio	n:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)	-8-10		
DATE	STEP	Description of NC Section A	Initial	Action Description				Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date				

Work Order ID 57825



Page 2

April 16, 2010 11:31:14 AM

Required Date: 23/04/2010

Item ID: **Revision ID:** D3493-1

Accept



Setup Start



Stop

Item Name: Start Date:

16/04/2010

Washer

Start Qty: 40.00

Req'd Qty: 40.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date:_____

Tooling:

SPC (Y/N):

Set Up/

Date:

Date:

Start



Run

Sequence ID/ Work Center ID

130

Packaging

Packaging

Description

Operation

Identify as per dwg & Stock Location: 0 65

Memo

Memo

Date:

Run Hours 0.00

0.00

Draw Rev.

Plan Code

Accept Qty

Reject Reject Qty Number

Stop

Insp. Stamp

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

10/04/20 xt

Dart Aerospa	ace Ltd
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W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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								ļ		
Part No	•	PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ	 A :	Date:	
		esolution:								
NCR:			WORK ORDE	R NON-CONFORMA	NCE	(NCR)	1			
DATE	STEP	Description of NC		ection B Ve			ation	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng			Section C		Chief Eng	QC Inspector
·										
						•				
								:		

April 16, 2010 11:31:18 AM

Work Order ID: 57825

D3493-1

Washer Parent Item Name:

Comments:

Parent Item:

IPP Rev: A New Issue 06-02-28 JLM

Start Date: 16/04/2010

Required Date: 23/04/2010

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R1.000		Purchased	No			100	f	88.9700	1.2253			

304 round bar 1.00

Warehouse	Loc Qty	Loc Code				
Location			i			
Main Warehouse			ŀ			
MAT029	88.97					
109508	12.5					11.
109541	27.8			-1.3	_اک	10/04/12
113457	48 67			`		

Dari Aerospace Li	rospace Ltd	pace Lte	S	ero	Α	art	D
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W/O:		101	WC	RK ORDER CHANG	ES				· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								-	
Part No	<u> </u>	PAR #:	Fault Cated	norv:	NCR: Ye	s No DC	Δ-	Date:	
		esolution:							
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Corrective Action			on B	Verif	cation	Approval	Approval
DATE	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat	ı& ∣ _{Sec}	tion C	Chief Eng	QC Inspector	

DART AEROSPACE LTD	Work Order:	57825
Description: Washer	Part Number:	D3493-1
Inspection Dwg: D3493 Rev: A		Page 1 of 1

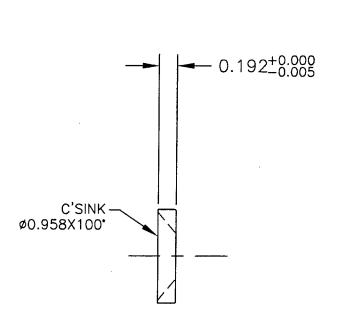
		FIR	ST AF	RTICLE INSP	ECTION	CHEC	KLIST		
			X	First Article	F	Prototy	/pe		
	rawing nension	Tolerand	e	Actual Dimension	Accept	Rejec		ethod of spection	Comments
	0.192	+0.000/-0.0	005	. 191					
Ø	1.000	+/-0.010)	998					
Ø0.9	58 x 100°	+/-0.010)	. 960×100°					
Ø	0.516	+0.008/-0.0	001	519					
	· · · · · · · · · · · · · · · · · · ·								
					, , , ,				
						1			
Measu	ared by:	SL	Au	udited by:	\$	Р	rototyp	e Approval:	N/A
-	Date:	10/04/18	Date: 10/	——————————————————————————————————————			Date:	N/A	
Rev	Date	Change			/			Revised by	Approved
A	06.09.01	New Issue						KJ/JLM	
В	06.11.22	Ø0.516 dimen		moved				KJ/JLM	_ \

Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	GES					<u> </u>
DATE	STEP	PR	OCEDURE CHA	ANGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						_	00			
				•						
										
Part No		PAR #:	Fault Cate	egory:	NCR: `	Yes N	o DQ	4 :	_ Date: _	
	Re	solution:							Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (VCR)			,	
DATE	STEP	Description of NC				ction B			Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Verification Section C		Chief Eng	QC Inspector
<u> </u>	1		1		1		1		1	1



	DESIGN	PH	DRAWN BY	DART	AEROSPACE USA, INC.
	CHECKED	.nd	APPROVED A	DRAWING NO.	REV. A
		#	1	D3493	SHEET 1 OF 1
1	DATE			TITLE	SCALE
	06.01	.04		WASHER	1:1
	Α		06.01.04	NEW ISSU	JE



ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER Ø1.000 Ø0.516

SHOP COPY **RETURN TO**

D3493-1 WASHER

D3493-1 WASHER

MATERIAL:

AISI 304/316 STAINLESS STEEL Ø1.000 ROUND BAR

(REF DART MATERIAL SPEC M304R1.000)

- ALL DIMENSIONS ARE IN INCHES 2)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES 0.005 TO 0.010 MAX



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W/O:			W	ORK ORDER CHANG	GES				
DATE	STEP	PR	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
									•,
Part No					NCR: Yes No DQA: Date:				
	Re			QA: N/C Closed: Date: _					
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	P Description of NC Section A	Corrective Action Section B			VARITICAL		Approval	Approval
DAIL			Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	ion C	Chief Eng	QC Inspector